

Current Status of Claims

1. *(original)* A method for manufacturing a long-term storage container for storage of radioactive material to inhibit radioactive radiation therefrom to the outside of the container, said container having a bottom and upright wall extending therefrom, the top of said container to be closed off by a screw-on lid, said container having an integral inner container part of a first material with a bottom and upright wall, an integral outer container part of a second material with a bottom and upright wall, and radioactive radiation inhibiting material in an inter-space between the walls and bottoms of said inner and outer container parts; the method comprising:
- integrally casting in a first mould through injection moulding a first container part having a bottom and a wall,
 - removing the first container part from the first mould;
 - integrally casting in a second and separately located mould through injection or pressure moulding an inter-space container part of said radioactive radiation inhibiting material, said inter-space container part having a bottom and a wall and forming a second container part,
 - removing said inter-space container part from the second mould,
 - placing the first container part in a third mould ,
 - placing said inter-space container in fitting engagement with exterior face of the first container part to form a first assembly of container parts,
 - in the third mould locating the first assembly of container parts to cause said inter-space container part to be in spaced relationship to a mould member of the third mould, so as to form a cavity between the mould member of the third mould and the outside of the inter-space container part, the inside of the first container part being fitted onto a core member of the third mould,
 - through injection moulding into said cavity integrally casting the outer container part forming a third container part having a side wall and a bottom, said third container part engaging the exterior faces of the inter-space container part, and
 - removing from the third mould a second assembly of container parts formed by the first, second and third container parts to provide said storage container.

2. *(original)* A method according to claim 1, wherein a further first container part is cast simultaneously with the casting of the third container part.

3. *(previously presented)* A method for manufacturing a long-term storage container for storage of radioactive material to inhibit radioactive radiation therefrom, said container having a bottom and upright wall extending therefrom to the outside of the container, the top of said container to be closed off by a screw-on lid, said container having

5 an integral inner container part of a first material with a bottom and upright wall, an integral outer container part of a second material with a bottom and upright wall, and radioactive radiation inhibiting material in an inter-space between the walls and bottoms of said inner and outer

10 container parts; the method comprising:

- integrally casting in a first mould through injection moulding a first container part having a bottom and a wall,
- integrally casting in a second and separately located mould through injection or pressure moulding an inter-space container part of
- 15 said radioactive radiation inhibiting material, said inter-space container part having a bottom and a wall and forming a second container part, and removing said inter-space container part from the second mould,
- separating the first container part from a first part of the first mould which formed exterior side wall and bottom faces of the first
- 20 integral container part,
- providing the first mould with a second part having a third mould
- placing said inter-space container in fitting engagement with said exterior faces of the first container part to form a first assembly of container parts, the first container part being in engagement with a
- 25 portion of the second part of the first mould;
- locating in the third mould the first assembly of container parts and causing said inter-space container part to be in spaced relationship to a mould member of the third mould, so as to form a cavity between the mould member of the third mould and the outside of the inter-space
- 30 container part, the second part of the first mould having a portion inside the first container part to support it during moulding in the third mould, and a top of the second part of the first mould configured to be used to close off an open end of said mould member of the third mould,
- through injection moulding into said cavity integrally casting a
- 35 third container part having a side wall and a bottom, and
- removing from the third mould a second assembly of container parts formed by the first, second and third container parts to provide said storage container.

4. *(previously presented)* A method according to claim 1, wherein said first and second materials are high density polyethylene materials.

5. *(previously presented)* A method according to claim 1 wherein said inter-space container part forming the second container part is moulded from a radioactive radiation inhibiting material which is selectable from one of: lead, lead alloy, tin and tin alloy.

6. *(previously presented)* A method according to claim 1 wherein the casting of the third container part in addition provides for threads on the outside of said outer container part, said threads dimensioned to enable fitting engagement with threads on a lid to be
5 fitted by screwing onto the storage container.

7. *(original)* A method according to claim 6, wherein the provision of threads on the outer container part also includes provision of locking means configured for non-releasable engagement with a locking member on said lid when said lid is fully screwed onto the storage
5 container.

8. *(cancelled)*

9. *(previously presented)* A method for manufacturing a radioactive radiation inhibiting lid suitable for fitting onto a top region of a storage container for long term storage of radioactive material and inhibiting radioactive radiation therefrom to the outside of the lid, the method comprising:

- providing a pre-cast second lid member made from radioactive radiation inhibiting material, suitably selected from lead, lead alloy, tin and tin alloy,
- placing the second lid member in a mould for moulding around at least one face and the edges thereof a first and integral lid member through injection moulding of a first material, said integral first lid member provided with a top part and a skirt depending therefrom, said casting providing on an inside of said skirt threads to enable fitting engagement with external threads on said storage container, said first lid member further providing in said top part at least one recess in which said second lid member is located, and
- removing from the first mould said first lid member with the second lid member in non-releasable engagement with the first lid member.

10. *(previously presented)* A method according to claim 9, wherein said first mould is configured to provide at a lower end of the skirt a lifting or engagement face suitable to cooperate with a container lifting device when such device is made to engage a container having a fitted lid.

11. *(previously presented)* A method according to claim 9, wherein said step of casting said threads includes providing a locking member for non-releasable engagement with locking means on the outside of the storage container when the lid is fully screwed onto the storage container.

12. *(previously presented)* A method according to claim 9, wherein said first material is high density polyethylene.

13. *(previously presented)* A method according to claim 9, wherein said radioactive radiation inhibiting material is selected from lead, lead alloy, tin and tin alloy.

14.-22. *(cancelled)*

23. *(previously presented)* A moulding apparatus for casting inner and outer container parts of a long-term storage container for storage of radioactive material to inhibit radioactive radiation therefrom to the outside of the container, the storage container to be provided with a radioactive radiation inhibiting material in an inter-space between said
5 inner and outer container parts, wherein said apparatus comprises two separate moulds:
a primary mould having a mould cavity for casting an inner container part having an integral bottom wall and upright wall, and
10 a secondary mould having a mould cavity for casting an outer container part having an integral bottom wall and upright wall, said secondary mould having a member for supporting the inner container part with a separately provided inter-space container part fitted thereon when casting the outer container part such that the outer container part engages the
15 outside face of the inter-space container part.

24. *(original)* A moulding apparatus according to claim 23, wherein the apparatus is provided with means for operating both the primary mould and the secondary mould simultaneously.

25. *(previously presented)* A method according to claim 3, wherein said first and second materials are elected from the group of-high density polyethylene and ceramic materials.

26. *(previously presented)* A method according to claim 3, wherein said inter-space container part forming the second container part is moulded from a radioactive radiation inhibiting material which is selectable from one of: lead, lead alloy, tin and tin alloy.

27. *(previously presented)* A method according to claim 3, wherein the casting of the third container part in addition provides for threads on the outside of said outer container part, said threads dimensioned to enable fitting engagement with threads on a lid to be fitted by screwing onto the storage container.

28. (*previously presented*) A method according to claim 27,
wherein the provision of threads on the outer container part also includes
provision of locking means configured for non-releasable engagement with
a locking member on said lid when said lid is fully screwed onto the storage
5 container.

29. (*cancelled*)